

## CLAIMS

We claim:

1 1. A method of forming a security enclosure, comprising:  
2 providing an electronic assembly;  
3 enclosing the assembly in a tamper respondent wrap,  
4 such that the wrap forms fold lines at a first and second  
5 end of the assembly;  
6 placing the enclosed assembly in a fixture, wherein the  
7 fixture comprises a base upon which the assembly rests, a  
8 first stationary arm mounted on the base holding the fold  
9 lines at the first end of the assembly, a second arm  
10 slidably mounted on the base, and a traversing mechanism to  
11 bias the second arm toward the fold lines at the second end  
12 of the assembly; and  
13 heating the enclosed assembly.

1 2. The method of claim 1, further comprising heating the  
2 enclosed assembly at a temperature of approximately 60 °C.

1 3. The method of claim 1, further comprising heating the  
2 enclosed assembly at a temperature of approximately 40-90  
3 °C.

1 4. The method of claim 1, further comprising heating the  
2 enclosed assembly for approximately 1 hour.

1 5. The method of claim 1, wherein the fixture comprises a  
2 clamping device.

1 6. The method of claim 1, wherein the tamper respondent wrap  
2 comprises a flexible material having tamper respondent  
3 detection devices.

1 7. The method of claim 1, wherein the tamper respondent wrap  
2 comprises:

3 at least one pierce and laser respondent layer;  
4 a delamination respondent layer; and  
5 an adhesive between the pierce and laser respondent  
6 layer and the delamination respondent layer.

1 8. The method of claim 7, wherein the pierce and laser  
2 respondent layer and the delamination respondent layer  
3 comprise a plurality of ink lines on at least one side of  
4 the pierce and laser respondent layer and the delamination  
5 respondent layer.

1 9. The method of claim 1, wherein the electronic assembly  
2 comprises a cryptographic processor.

1 10. The method of claim 9, wherein the cryptographic  
2 processor comprises a printed circuit board, having mounted  
3 thereon:

4 an encryption module to carry secured sensitive  
5 information;

6 a memory to store a key necessary to access the  
7 information;

8 an erase circuit to erase the information in the  
9 encryption module in the event the tamper respondent wrap is  
10 breached; and

11 an enclosure monitor to activate the erase circuit in  
12 the event a breach is detected.

1 11. A method of producing a tamper respondent enclosure,  
2 comprising:

3 enclosing a cryptographic processor in a tamper  
4 respondent sheet, wherein an adhesive material secures the  
5 enclosure;

6 holding the enclosed cryptographic processor such that  
7 the adhesive material remains intact; and

8 applying heat to the enclosed cryptographic processor  
9 to strengthen the adhesive material.

10 12. The method of claim 11, further including holding the  
11 enclosed cryptographic processor in a clamping device.

12 13. The method of claim 11, further including applying heat  
13 at a temperature of approximately 60 °C.

14 14. The method of claim 11, further including applying heat  
15 at a temperature of approximately 50-70 °C.

1 15. A method of forming a security enclosure, comprising:  
2 providing a circuit card;  
3 enclosing the card in a tamper respondent cloth,  
4 wherein an adhesive secures fold lines of the cloth;  
5 holding the fold lines of the cloth to maintain  
6 adhesive contact; and  
7 heating the enclosed card.

1 16. The method of claim 15, further comprising holding the  
2 cloth in a clamping device to maintain the adhesive contact.

1 17. The method of claim 16, wherein the clamping device  
2 comprises:

3 a base upon which a security enclosure rests;  
4 a first stationary arm mounted on the base, which holds  
5 a first end of the security enclosure;  
6 a second arm slidably mounted on the base; and  
7 a traversing mechanism to bias the second arm toward a  
8 second end of the security enclosure.



1 21. A method of assembling a security enclosure comprising:  
2 providing a fixture;  
3 providing an enclosure having a cloth member thereon;  
4 placing the enclosure in the fixture;  
5 heating the enclosure; and  
6 removing the enclosure from the fixture.

1 22. The method of claim 21, wherein the fixture comprises a  
2 clamping device.

1 23. The method of claim 22, wherein the clamping device  
2 comprises:

3 a base upon which a security enclosure rests;  
4 a first stationary arm mounted on the base, which holds  
5 a first end of the security enclosure;  
6 a second arm slidably mounted on the base; and  
7 a traversing mechanism to bias the second arm toward a  
8 second end of the security enclosure.

1 24. The method of claim 21, wherein the enclosure comprises  
2 a circuit assembly having a tamper respondent cloth wrapped  
3 therearound.

1        25. The method of claim 21, wherein heating comprises  
2        exposing the enclosure to a temperature of approximately 50-  
3        70 °C for about 1 hour.

